

Work Order ID 50846

July 31, 2009 8:34:46 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 08/20/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/04/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-08-04 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2580	Rev D								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy D205-634 bluefile & type labels per PPP D205-634-041		CHG002						
110		0.00							
	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	1-Bend as per program D2580.C on CNC Bender and Folio FT009								
	2-Cut tubes as per Dwg. D2580								

N/A

)

11 9-8-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.



BE 09/08/11

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

7 S of 10/11



6

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

0.00

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R/□□ Aluminum Rod

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R/□□ Aluminum Rod

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

- AWM 7-8-12

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00

27 S 09/08/13

(X) 0

QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

27 S 09/08/13

(X) 0

QC

Memo

0.00

Quality Control

170

Pressure Wash per QSI005 4.3

0.00

27 Jf 09/08/13

(X) 0

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum Memo M112260 START TIME: 12:00pm OVEN TEMPERATURE: 320°F FINISH TIME: 12:30pm	0.00 0.00							W 09/08/17 (X1) ✓
190  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							⇒ S 09/08/18 (X1) ✓

W/O:		WORK ORDER CHANGES					
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Page 6

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Required Date: 09/04/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of
Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112391
Sikaflex expire date: 10/20

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as
per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with
Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112391
Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: _____

MD 09/08/20

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July 31, 2009 8:34:46 AM

Page 7

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

2) S 08/18/21 (10) 8

220

Packaging

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041
Location: _____
PPP Rev: _____

ADP

51033

(14) 8

9/8/25

230

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

09/08/25 HJ

PL 09-8-25

Picklist Print

July 31, 2009 8:34:45 AM

Page 1

Work Order ID: 50846

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube


Start Date: 08/20/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD 		Manufactured	No			110	Each	7.0000	1.0000			
205 Skidtube bent detail												

DM 9-8-7
BS0757

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	7	
48616	1	
50760	6	

D2576-3RevG

Manufactured No

140 Each 165.0000 1.0000



Step (maching detail)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	165	
43504	62	
46661	103	

L BE 9-8-11

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Picklist Print

July 31, 2009 8:34:45 AM

Work Order ID: 50846

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Start Date: 08/20/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			140	Each	412.0000	20.0000			

Crossbolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	412	
43988	4	
46434	4	
46956	12	
47797	338	
48272	54	

20 BE 09/08/11

D2855RevA

Manufactured No

200

Each

66.0000

1.0000



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP6	52	
50513	52	

Main Warehouse

ST	14	
10360	2	
35663	7	
41340	1	
42343	3	
42806	2	
50513	-1	

21 MD 09/08/20

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Replacement Skidtube


Start Date: 08/20/2009

Required Date: 09/04/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A  Bolt		Purchased	No			200	Each	2,560.000	2.0000			



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 2560

100188 246

105057 2246

15205 68

21 MD 09/08/20

AN960JD10L

Purchased

No

200

Each

6,911.000

2.0000



Washer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 6911

101291 16

104885 153

105793 236

109632 1506

110985 5000

21 MD 09/08/20

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

ALS7-1032-130

Purchased

No

200

Each

3,706.000

50.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3706

105855

16

108606

52

111529

1638

111779

2000

AN3C4A

Purchased

No

200

Each

2,071.000

50.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2071

112082

121

112314

1950

x50 mo 09/08/20

x50 mo 09/08/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			200	Each	4,591.000	50.0000			

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

4491

112116

4491

D3566-13RevC

Manufactured

No



Gasket

200

Each

47.0000

1.0000



X50 MD 09/08/20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47

45717

1

46889

5

47435

7

48166

18

50265

16

X1 MD 09/08/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D3566-5RevC		Manufactured	No			200	Each	22.0000	1.0000			

Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

36113

46186

47318

48167

22

1

1

1

19

200

Each

34.0000

2.0000

(X) MD 09/08/20

D3566-1RevC

Manufactured

No



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46349

47434

48165

48557

50278

34

1

2

8

11

12

(X) MD 09/08/20

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D3564-11RevD		Manufactured	No			200	Each	30.0000	1.0000			
Wearshoe												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 30

45823 1

47432 7

48553 12

50112 10

D3564-13RevD

Manufactured No



200

Each

55.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP17 35

48554 13

50270 22

Main Warehouse

ST 20

45409 3

46495 10

47867 7

XI MD 09/08/20

XI MD 09/08/20

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D3564-9RevD		Manufactured	No			200	Each	17.0000	1.0000			
												
Wearshoe												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

44659

1

45825

1

47316

4

48556

11

XL MD 09/08/20

D3564-5RevD

Manufactured No

200

Each

22.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

34806

2

Main Warehouse

FP19

12

48555

12

Main Warehouse

ST

8

45824

1

47433

1

48164

6

XL MD 09/08/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Comments:

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Required Date: 09/04/2009

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3RevC 		Manufactured	No			200	Each	894.0000	16.0000			
O-Ring, 205 Skidtube												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	894	
27168	44	
29908	850	

D2594-1RevC 		Manufactured	No			200	Each	700.0000	16.0000			
Plug, 205 Skidtube												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	700	
42221	16	
42807	92	
43884	87	
46435	3	
47251	502	

X16 MD 09/08/20

X16 MD 09/08/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

10-20-60
9128-05 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07-06-28-11

Diagram illustrating the underside of the D2576-3 step, showing the locations for grinding and flushing. The diagram includes labels for:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576

Technical drawing of a circular component with a central hole and a rectangular slot. The drawing includes the following labels and dimensions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to two locations on the outer rim of the component.
- #0.208**: Dimension indicating the diameter of the central hole.
- D2855 CAP**: Points to the cap of the central hole.
- AN3-5A BOLT (1)**: Points to the bolt securing the cap.
- AN980J/D10L WASHER (1)**: Points to the washer under the bolt.
- (2 PLACES)**: Points to the two locations on the outer rim where the cap is installed.
- SEAL WITH SIKAFLEX-241/-291**: Points to the sealant applied to the cap.
- 0.40**: Dimension indicating the width of the rectangular slot.

Diagram illustrating the assembly of a propeller hub, showing the following components and instructions:

- D2579 SPACER**: Indicated by a line pointing to the top of the hub.
- D2596 WEB (REF)**: Indicated by a line pointing to the central web of the propeller.
- ALS7-1032-130 (REF) (TYP 50 PLACES)**: Indicated by a line pointing to the bottom of the hub.
- 5**: A circled number 5 in a triangle, indicating a quantity or count.

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO #0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

37.50
DISTANCE TO AFT END
OF D2596 WEB
3
7
1.750
1.750
#0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL A
8.750
17.375
26.000
34.188
57.313 (REF)
7 EQUAL SPACES
8.188 PITCH
38.0
91.500
190.0
(D2500-1)

Technical drawing of a horizontal curve with two circular arcs. The left arc has a radius of 13.4 and a central angle of 4 degrees. The right arc has a radius of 32.0 ± 1.0 and a central angle of 4 degrees. The distance between the hole and the tangent point for the left arc is 1.0. The distance between the hole and the tangent point for the right arc is 1.0. The total length of the curve is 20.0. The offset from the centerline to the hole is 1.4. The offset from the centerline to the tangent point is 11.0. The hole diameter is Ø0.640.

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5 1.5 1.5 D

P P P P P P P

D

8

1.5 1.5 1.5

REFER TO DETAIL C





D3566-1 D3566-5 D3566-1 D3566-13

D3564-11 D3564-5 D3564-9 D3564-13

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

DESIGN	JJ	DRAWN BY	
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CHECKED		APPROVED	
DATE			
07.02.27			

DART AEROSPACE LTD.
HAMMERSLEY, ONTARIO, CANADA

DRAWING NO.	REV. D
D2580	SHEET 2 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

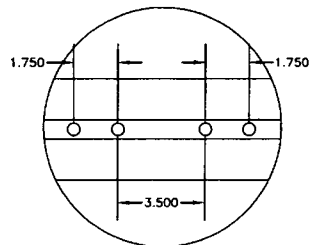
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

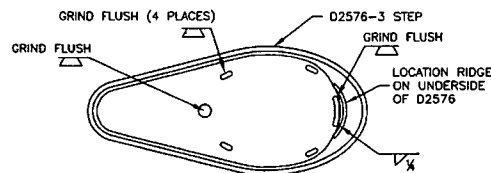
NOTE: Date & initial all entries

DETAIL E
SCALE 5:24

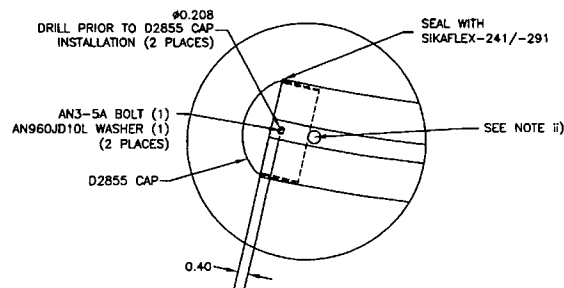


RELEASED
07.02.27

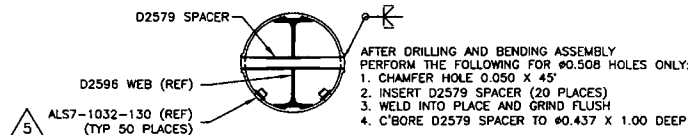
DETAIL F
SCALE 5:24



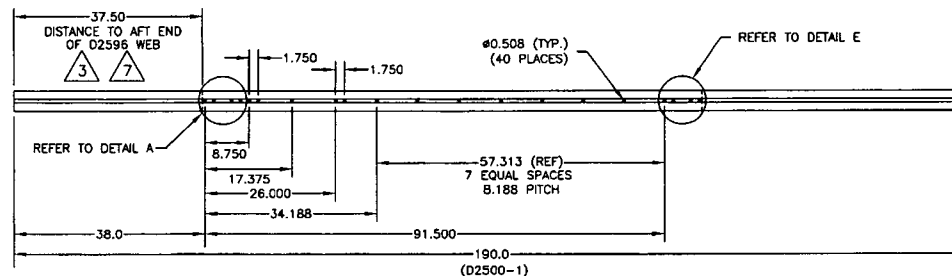
DETAIL G
SCALE 5:24



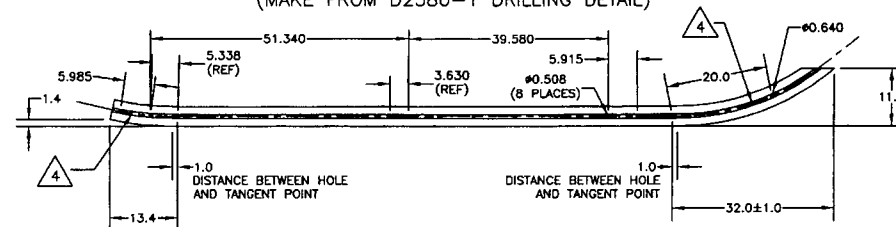
SECTION H-H
SCALE 5:24



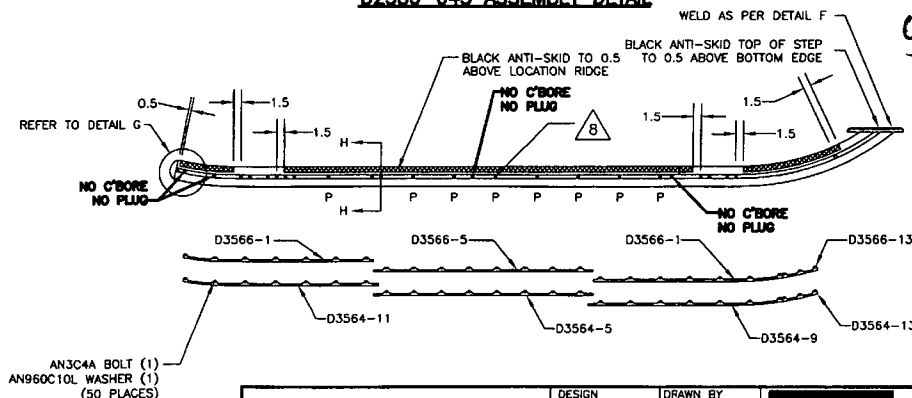
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD.
CHECKED <i>RH</i>	APPROVED <i>RH</i>	DRAWING NO. D2580	REV. 0
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SHEET 3 OF 3	SCALE 1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 206

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 50844
Part number: D205 634 041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier [Signature]

Date of Test Coupon 09.08.13

Welder [Signature]

Date of Test Coupon 09.08.13

The above named individual is qualified in accordance with AWS D17.1.2001 to weld